

Date: Thursday, 7/13/2006 3:38:03 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 27898		
Estimate Number	: 11168		
P.O. Number	: N/A	Part Number	: D22823
This Issue	: 7/13/2006	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Number	: D2282 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26815	Drawing Revision	: E
Written By	: <i>[Signature]</i>	Material	: N/A
Checked & Approved By	: <i>[Signature]</i>	Due Date	: 8/15/2006
Comment	: Est Rev:A	Qty:	100
	Removed from 9 Digit	Um:	Each
05-12-02 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0675W091	304 RD Tube .675 x .091W
		Comment: Qty.: 0.2078 f(s)/Unit Total : 20.7795 f(s) Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness (M304TR0.675W.091) Batch B19524 → 20.7795 <i>J.G 06/09/06 100</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA188 <i>J.G 06/09/06 100</i>
		2-Deburr
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>J.G 06/09/06 100</i>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>J.G 06/09/06 100</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 393 <i>C.G/9/1 200</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 06/09/07

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 7/13/2006 3:38:04 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 27898

Part Number: D22823

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC

DOCUMENT CONTROL



(108)

Comment: DOCUMENT CONTROL

Inspection Level 21

 06/09/07

Job Completion



U 06-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27898
Description: Handle Tube	Part Number:	D2282-3
Inspection Dwg: D2282	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

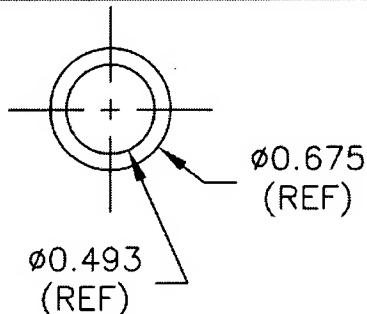
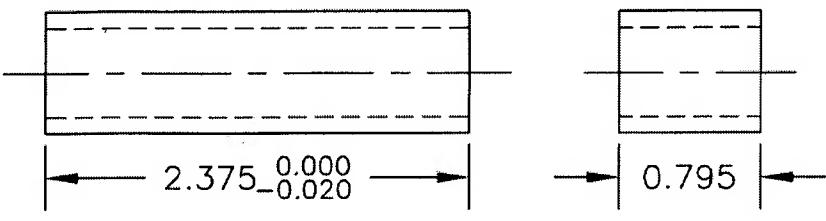
Measured by:	J.G	Audited by:	R.G	Prototype Approval:	N/A
Date:	06/09/06	Date:	06.09.06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Tolerance changed	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	<i>[Signature]</i>

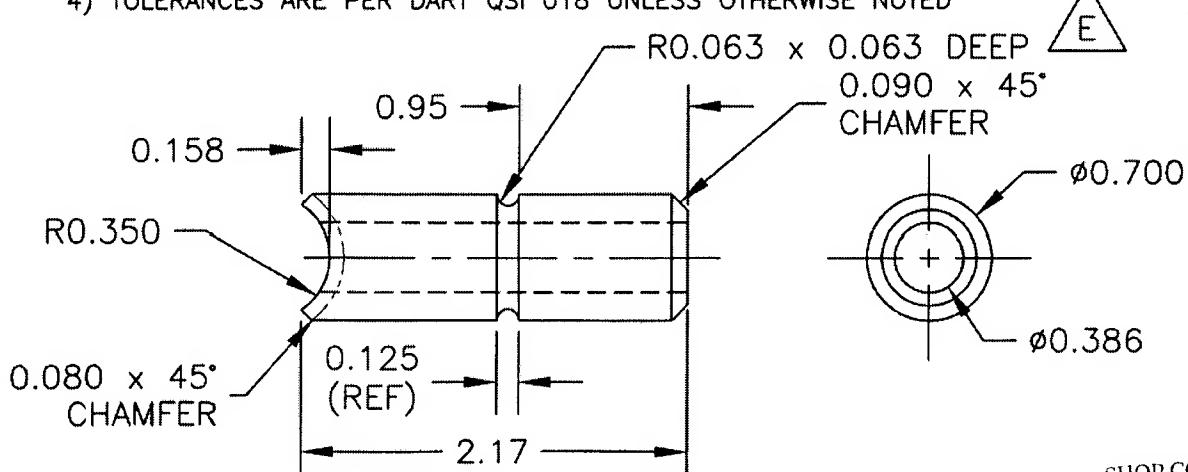
DART

DESIGN BW	DRAWN BY <i>PZ</i>	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
CHECKED <i>DP</i>	APPROVED <i>100%</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
05/09/16

**D2282-3****D****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D****D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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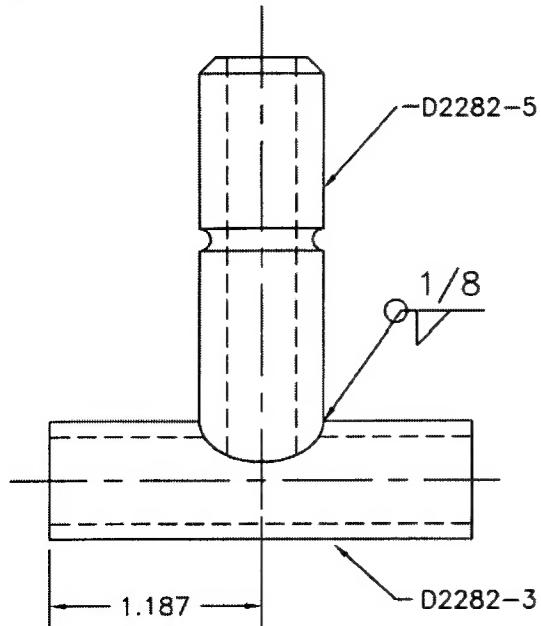
SUBJECT TO AMENDMENT
E WITHOUT NOTICEWORK ORDER
NO. 27898

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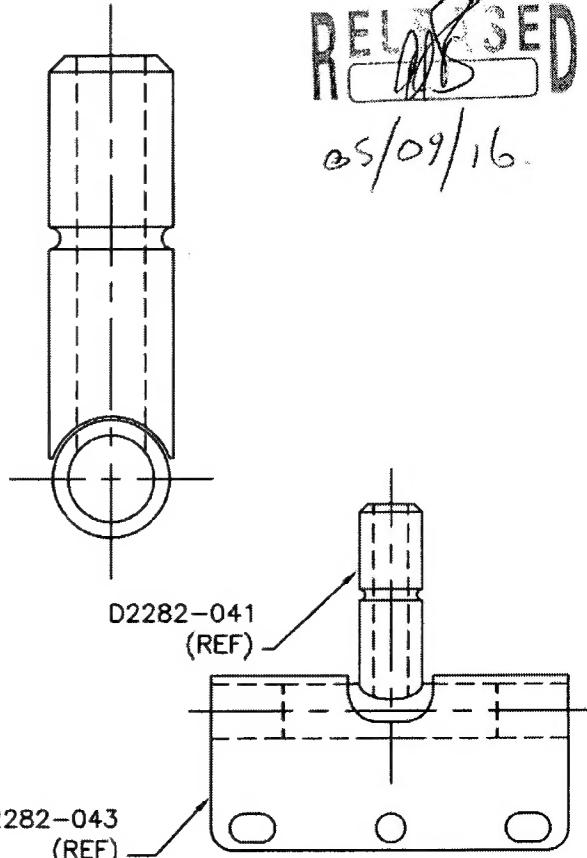
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DART

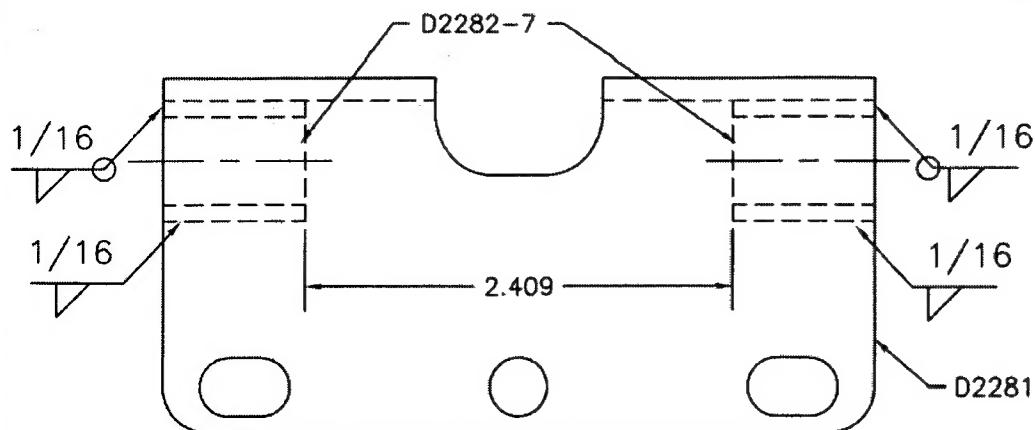
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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